

Date: Monday, 4/10/2006 11:13:52 AM  
User: Kim Johnston

## Process Sheet

Split  
SB 06/05/16

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 26612  
Estimate Number : 12308  
P.O. Number : N/A  
This Issue : 4/10/2006 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : SMALL /MED FAB  
Previous Run : 26462  
Written By : SEE COMMENT BELOW  
Checked & Approved By : SEE ABOVE USER & DATE  
Comment : est rev A 06.03.02 New issue EC

Drawing Name : BLOWER MOTOR SUPPORT  
Part Number : D34711  
Drawing Number : D3471 REV.A  
Project Number : N/A  
Drawing Revision : A  
Material : N/A  
Due Date : 4/28/2006 Qty: 1 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 1042

Email or Ship DXF file to vendor

Cut per Dwg D3471 flat pattern D3471-1F

possible supplier: GFI

Material release note required

C 2006/04/28

2.0 D34711F BASE FLAT PATTERN



Comment: Qty.: 1.0000 sf(s)/Unit Total: 1.0000 sf(s)

SUPPORT FLAT PATTERN

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

SB 06/04/28

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D3471

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Bend as per dwg D3471

SB 06/05/16

H.M 06/05/03

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 26612

Part Number: D34711

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

FF 06.05.17

2

7.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

06.05.17

2

8.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: GA

8/3 06/05/17

2

9.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL  
Inspection Level 21

06/05/18

2

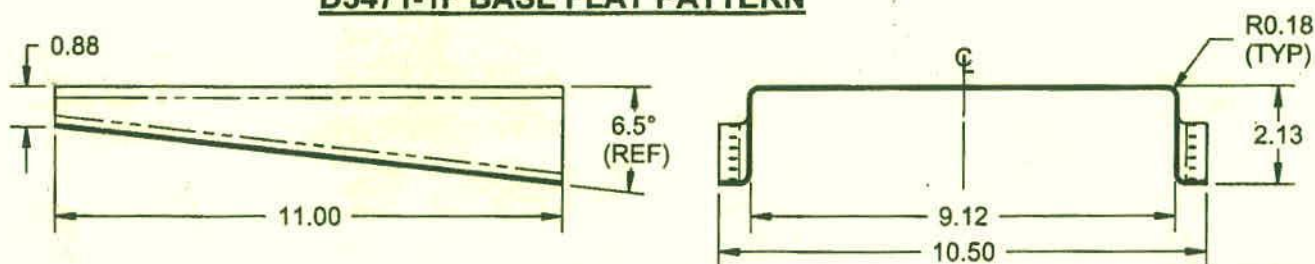
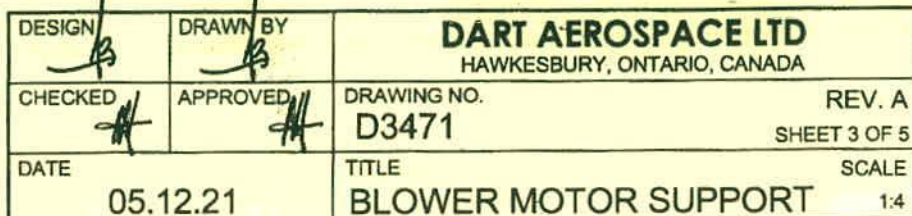
b Completion



W 06.05.18







### D3471-1 BASE BENDING DETAIL

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
1 SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26612

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da Lacelle

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rom: Jeff Mostat [jeff@industrialallaser.com]  
Sent: Tuesday, May 02, 2006 2:39 PM  
To: Linda Lacelle  
Subject: Re: certs



24ga 304 ss.pdf

Hi Linda,

You guys should have the certs for D3471-1, as it was cut from the material Dart purchased from Copper&Brass a couple of months back. (0.063 2024 t3 alum.)

Jeff Mostat  
Production Mgr.

Industrial Laser Cutting

ph.(604) 946-4152 ext.224  
fax(604) 946-4153

----- Original Message -----

From: "Linda Lacelle" <llacelle@dartaero.com>  
To: "Jeff Mostat (E-mail)" <jeff@industrialallaser.com>  
Sent: Tuesday, May 02, 2006 7:55 AM  
Subject: certs

>  
> Need certs asap for P.O 1042-  
> D3467-1  
> D3471-1  
>  
> thx  
> LL  
>

A large, stylized handwritten signature in black ink, consisting of a large loop and a long, sweeping stroke.





CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS  
Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.  
Per: *Mark J. Vrablec*  
Mark J. Vrablec  
Director of Manufacturing Davenport Works  
*Kenton P. Young*  
Kenton P. Young  
Quality Assurance Manager

525383 306094  
Ship Date B.L. No. Invoice No. Alcoa No. Item  
2005-11-07 87255 42246 DS-90097-1  
P.O. No./Govt Contract No. Customer  
CG1887 C&B-WHS-SCHAUMBERG

Ship To: COPPER & BRASS SALES, INC.  
415 STATE PARKWAY  
SCHAUMBURG, IL 60195

Item Description  
.0630 IN TK X 48.000 IN W X 144.000 IN LN CAT D 126153 (N) A/T 2024-  
T3 FLAT SHEET MILL FINISH {{ P/N 061847-0 }}. PER AMS-QQ-A-  
250/4 REV A & (EXCEPT OIL &  
MARKING) AMS4037 REV N & (EXCEPT MARKING)  
ASTMB209 REV 04 ((MARKED)) INTERLEAVED SKID  
WGT: 4500 LB QUAN TOL +/-10 %  
CQR D126153 REV 28 QRR 003140 CUST REQ 05-11-  
06 \*\*\* W/E 05-11-12 \*\*\*

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	306626	481111	3851	90	PC	

Notes for CQR: D126153.28  
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/4 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/4E, AMENDMENT 2.  
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/4E AMENDMENT 2 ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/4.

CQR: D126153.28 -Specification Limits -----

Temp Dir	UTS	TYS	EL4D
T3 Long Transv.	KSI	KSI	PCT
Max			
Min	63.0	42.0	15

Chemical Composition										Other	Other	Aluminum
	SI	FE	CU	MN	MG	CR	ZN	TI	Each	Total		
Alloy 2024	Max	.50	.50	4.9	.9	1.8	.10	.25	.15	.05	.15	
	Min			3.8	.30	1.2						
REMAIN												

Lot: 481111 -Mechanical, Physical, Metallography, Quantometer Results -----

Temp Dir	No. Test	UTS	TYS	EL4D
T3 Long Transv.	6	KSI	KSI	PCT
Max		68.4	45.5	20.5
Min		67.5	44.9	17.5

*2401042*  
*0605-02*  
*Aut. 06*



